

Date: Thursday, 6/7/2007 3:30:07 PM  
 User: Kim Johnston

## Process Sheet

*8/2/07*  
*8/3/07 10/23*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB ASSEMBLY  
 Job Number : 32856~( )  
 Estimate Number : 10194  
 P.O. Number :  
 This Issue : 6/7/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : SMALL / MED FAB  
 Previous Run : 31651  
 Part Number : D2174041  
 Drawing Number : D2174 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 6/30/2007 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : *D 07.06.08*  
 Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM  
 Est Rev:E As per Rev E 06-11-22 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D21741 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	<i>B 35503</i>

2.0 D21751 Angle LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	<i>B 32570</i>

3.0 D21752 Angle RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	<i>B 35342</i>

4.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: 19.0000 Each(s)/Unit Total : 380.0000 Each(s)  
 Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	<i>M105408 x 306mx, m104118 x 74mx.</i>

*mf 07-11-02*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>07/10/23</del>		<del>Split w/o</del> M/A No Split did on 1 w/o	<del>SB</del>	<del>07/10/23</del>	<del>17</del>		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:30:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 32856

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

mf 07-11-02

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 Alulor

count

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 07/11/

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-11-05

20x

9.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Screw

Batch: M9216

18

07/11/05

10.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Batch: M104625

18

07/11/05

11.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Batch: M105430

18

07/11/05

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

07/11/06 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 6/7/2007 3:30:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 32856

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



(221P)

Comment: INSPECT WORK TO CURRENT STEP

7/11/06 (x20)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

6/7/11/6 (20)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6/07.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

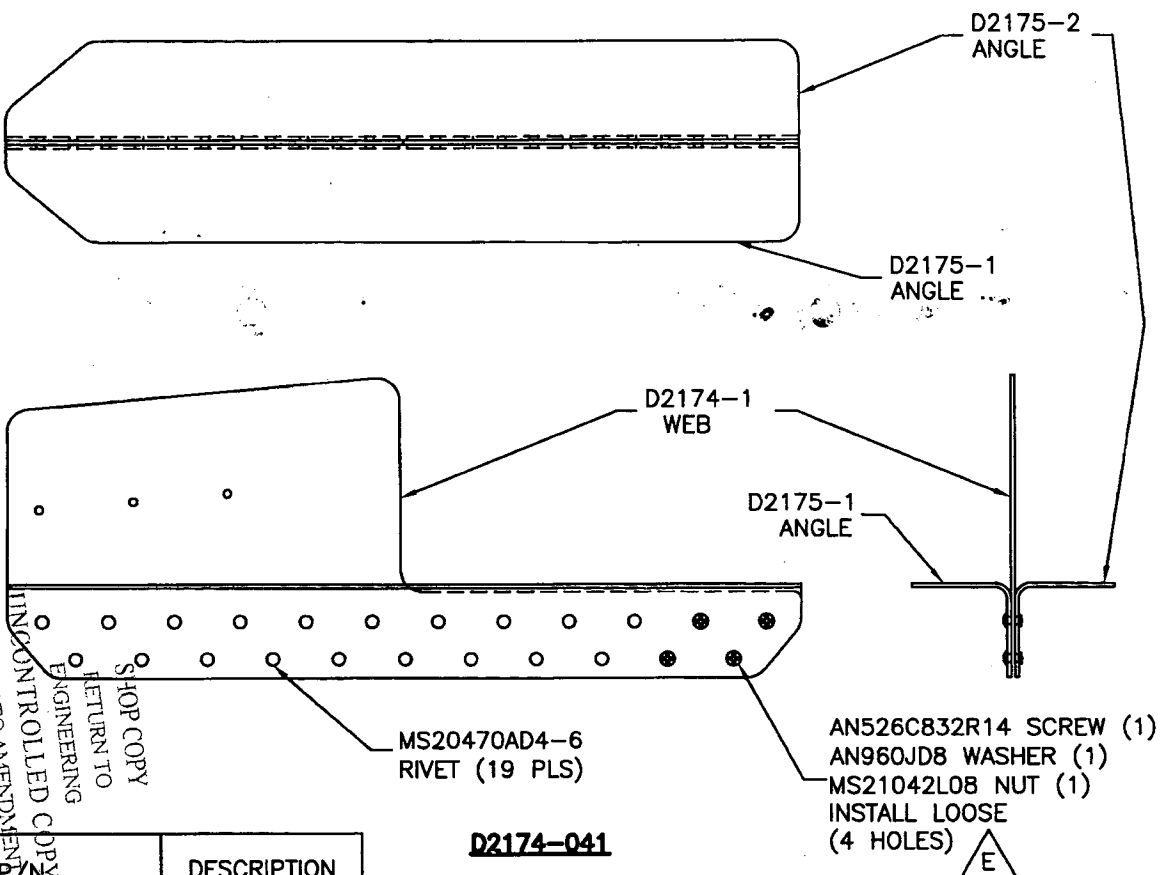
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED CH	DRAWING NO. D2174	REV. E
DATE 06.09.25		TITLE WEB ASSEMBLY	SHEET 1 OF 2
		SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



**D2174-041**

		DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

**NOTES:**

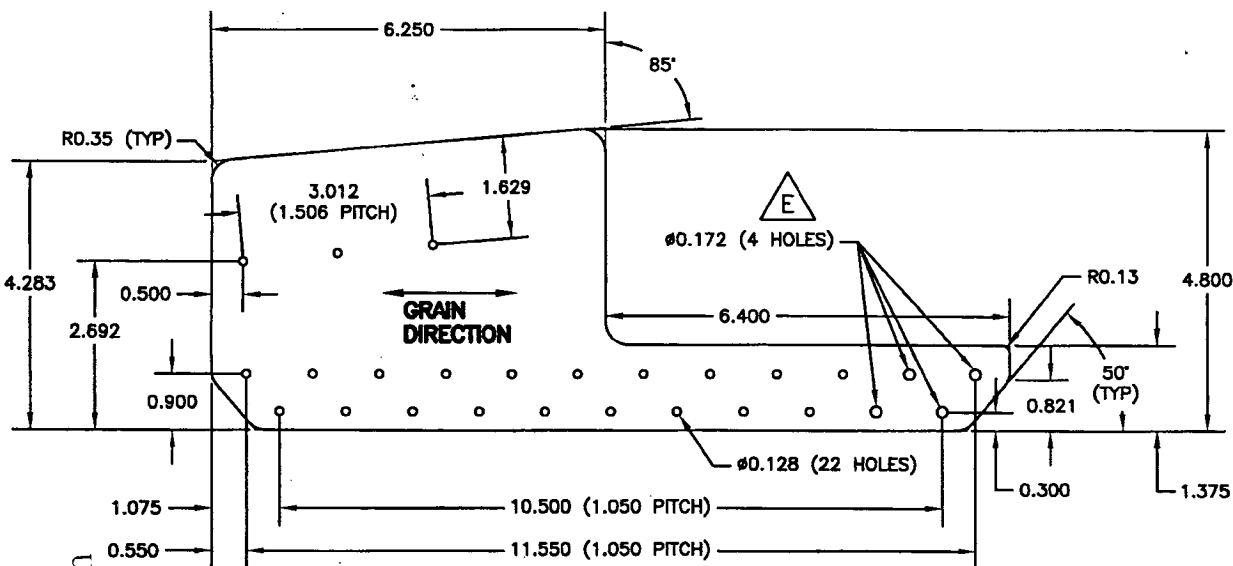
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

**RELEASED**  
06.10.13



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 2
PH	PH	D2174	
DATE	TITLE	SCALE	
06.09.25	WEB	1:3	

RELEASED  
06.10.23



D2174-1

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

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WORK ORDER

NO.

33856

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